

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028391**Date Inspected:** 13-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

This QA randomly observed ABF/JV qualified welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040R. The joint being welded was designated as 13E-E2.3.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

Excavations were recorded as:

Y= 135mm, L= 75mm, W= 20mm, D= 10mm

Y= 370mm, L= 75mm, W= 18mm, D= 10mm

Y= 525mm, L= 60mm, W= 20mm, D= 11mm

Y= 1350mm, L= 80mm, W= 22mm, D= 10mm

Y= 2125mm, L= 54mm, W= 21mm, D= 8mm

Y= 2800mm, L= 58mm, W= 11mm, D= 7mm

Y= 3635mm, L= 60mm, W= 20mm, D= 10mm

Y= 3800mm, L= 50mm, W= 25mm, D= 6mm

Y= 1790mm, L= 50mm, W= 20mm, D= 10mm (R2)

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QA UT Verification of Recordable Indications:

This QA Inspector performed Ultrasonic Testing (UT) of recordable indications previously discovered and documented by QC Ultrasonic technicians. This testing was performed at various locations of longitudinal and transverse "A" deck Complete Joint Penetration (CJP) welds.

This QA Inspector was instructed by QA Task Leader Bill Levell to compile UT data from all technicians tasked with this supplemental testing and to create a tracking spreadsheet. This QA Inspector generated the spreadsheet and emailed it to Task Leader Levell and Structures Materials Representative (SMR) Bahjat Dagher. In addition this QA Inspector generated a TL-6027 UT report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to work performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
